

51

DART AEROSPACE LTD	Work Order:	24173
Description: Tow Ring	Part Number:	D3407-041
Dwg: D3407 Rev. C	Qty:	
Ref:		Page 1 of 1

Step	Location	Procedure	By	Date	Qty												
1	DC	Issue Traveler		05.10.18													
2	WS	Weld D3407-1/-5 using welding rod TIG174 as per Dwg D3407 & QSI 004 Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D3407-1</td> <td>Stem</td> <td></td> </tr> <tr> <td>1</td> <td>D3407-5</td> <td>Ring</td> <td></td> </tr> </tbody> </table> Identify as D3407-041	Qty	Part Number	Description	Batch	1	D3407-1	Stem		1	D3407-5	Ring				
Qty	Part Number	Description	Batch														
1	D3407-1	Stem															
1	D3407-5	Ring															
3	QC9	Inspect weld															
4	QC5	Inspect work to Step 3															
5	FP	Powder Coat Gloss White (Ref: 4.3.5.2) as per QSI 005 4.3															
6	QC3	Inspect Powder Coat															
7	ST	Identify and Stock															
8	AC	Cost / part: _____															
9	DC	Close W/O Inspect Level 21															

Rev	Date	Change	Revised By	Approved
A	05.10.14	New issue	KJ/EC	

RELEASED
 05.10.18

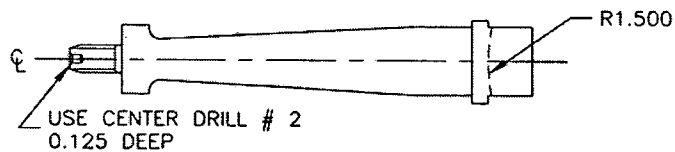
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

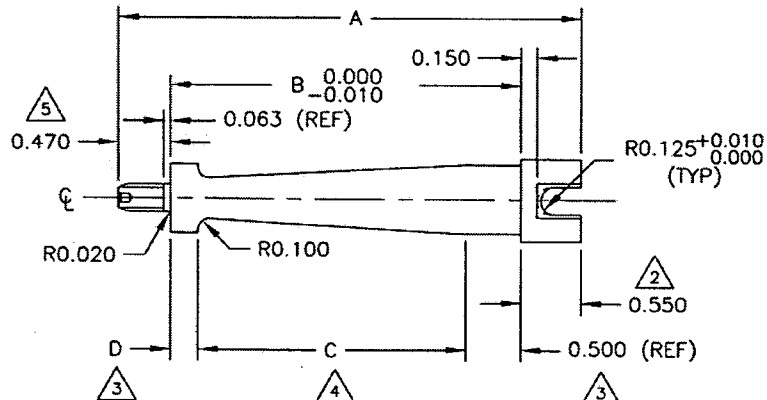
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



RELEASED

05.09.12



PART NUMBER	A	B	C	D
D3407-1	5.270	4.250	3.250	0.500
D3407-3	4.325	3.305	2.555	0.250

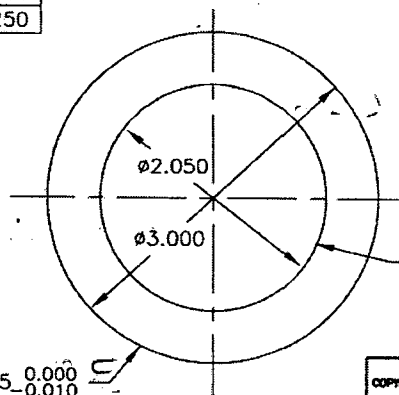
D3407-1/-3 STEM

D3407-1 AND D3407-3 STEM:

- 1) MATERIAL: 17-4 PH SS ROUND BAR (REF DART SPEC. M17-4-R0.750)
- 2) $\phi 0.750$ O.D.
- 3) $\phi 0.625$ O.D.
- 4) MACHINE UNIFORM TAPER FROM $\phi 0.363$ O.D. TO $\phi 0.625$ O.D.
- 5) 1/4-28 UNF THREAD WITH 0.063 GRIP, CLASS 2A
- 6) MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 7) UNLESS OTHERWISE INDICATED
- 8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

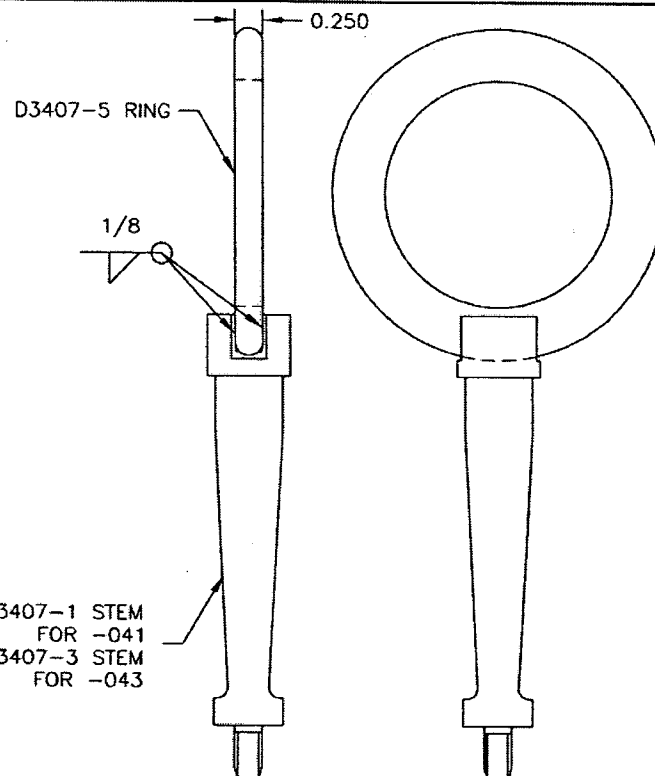
D3407-5 RING:

- 9) MATERIAL: 17-4 PH SS ROUND BAR (REF DART SPEC. M17-4-R3.000)
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



R0.125 $\frac{0.000}{0.010}$

D3407-5 RING



USE D3407-1 STEM FOR -041
USE D3407-3 STEM FOR -043

D3407-041 AND D3407-043 TOW RING:

- 11) WELD PER QSI 004 ON ALL EDGES BETWEEN STEM AND RING
- 12) FINISH: POWDER COAT WHITE (REF 4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
- 14) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DEBURR 0.010 TO 0.020

C	05.09.09	-1/-3 LONGER FOR FIT W/ WASHER
B	05.06.17	UPDATE DIAMETER, THREAD CLASS ADDED
A	05.03.16	NEW ISSUE
DESIGN	CP	DRAWN BY CP
CHECKED	#	APPROVED #
DATE	05.09.09	TOW RING
DRAWING NO.	D3407	REV. 0
DART DART AEROSPACE USA, INC.		SHEET 1 OF 1
PORT HADLOCK, VA		SCALE 1:1

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24173
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RETURN TO
ENGINEERING
FOR TOP COPY

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Sep 01, 2005
10:49 am

Work Order No	: 0024173	Department Code:	
Project Name	: D3407-041	Burden Flags	: NNNNNNNN
Project For	: TOW RING	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D3407-041	Invoice Number	:
Description	: Tow Ring	Invoice Amount	: 0.00
Manufactured	: No		
Amount Req'd	: 0	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 08-31-05		
Est Finish Date	: 09-29-05	Est Mark Up	: 0.000%
Act Finish Date	:	Actual Mark Up	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
=====					
Burden	0.00	0.00	0.00		
=====					
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00